

**Simply smart, double efficient:
The MAS compact system
for plastic recycling.**

Dry recovery and re-compounding



MAS redefines plastic recycling: economically and ecologically.

Versatile : Processing spectrum

Due to the versatile applicability, MAS compact systems are ideal for all impurities, which can be removed by friction, such as sand, soil or organic fibre contamination on:

- > stretch films
- > agricultural films
- > industrial film waste
- > plastic fibres
- > non woven materials
- > hollow bodies
- > tubs, flower pots
- > refrigerator regrind

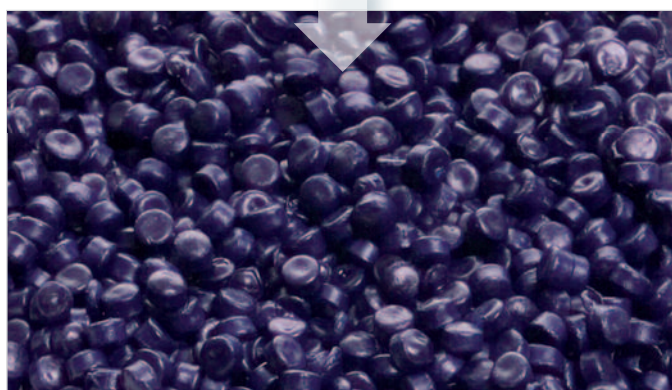
These materials are compounded into high quality pellets.

Multiple : Your benefits

The MAS compact system combines dry cleaning and extrusion with melt filtration and underwater pelletizing. The advantages, provided:

- > a gentle process on the material
- > cost savings of at least 50% per kg cleaned material compared to wet wash systems*
- > no water treatment system or operating permit required
- > no additional waste treatment/ disposal costs for heavily contaminated water
- > simple operation, low maintenance
- > reliable plant operating process
- > MAS extruder refines recycling goods into high-quality pellets
- > low energy consumption using additional heat recovery system (up to 40% lower energy costs)
- > **high profit margin due to increased efficiency**

* according to a comparative study incorporating empirical values



The alternative to wet cleaning: MAS compact systems.

Innovative : Technology

DRD (Double Rotor Disk) is the only technology that cleans films, fibres and non woven without using water! It combines a cleaning centrifuge and thermal dryer in one machine and guarantees a clean, dry process that delivers consistently high end-product quality. Consequently, MAS compact systems clean plastic waste very efficiently, making them the pioneering alternative to wet systems in the recycling process.

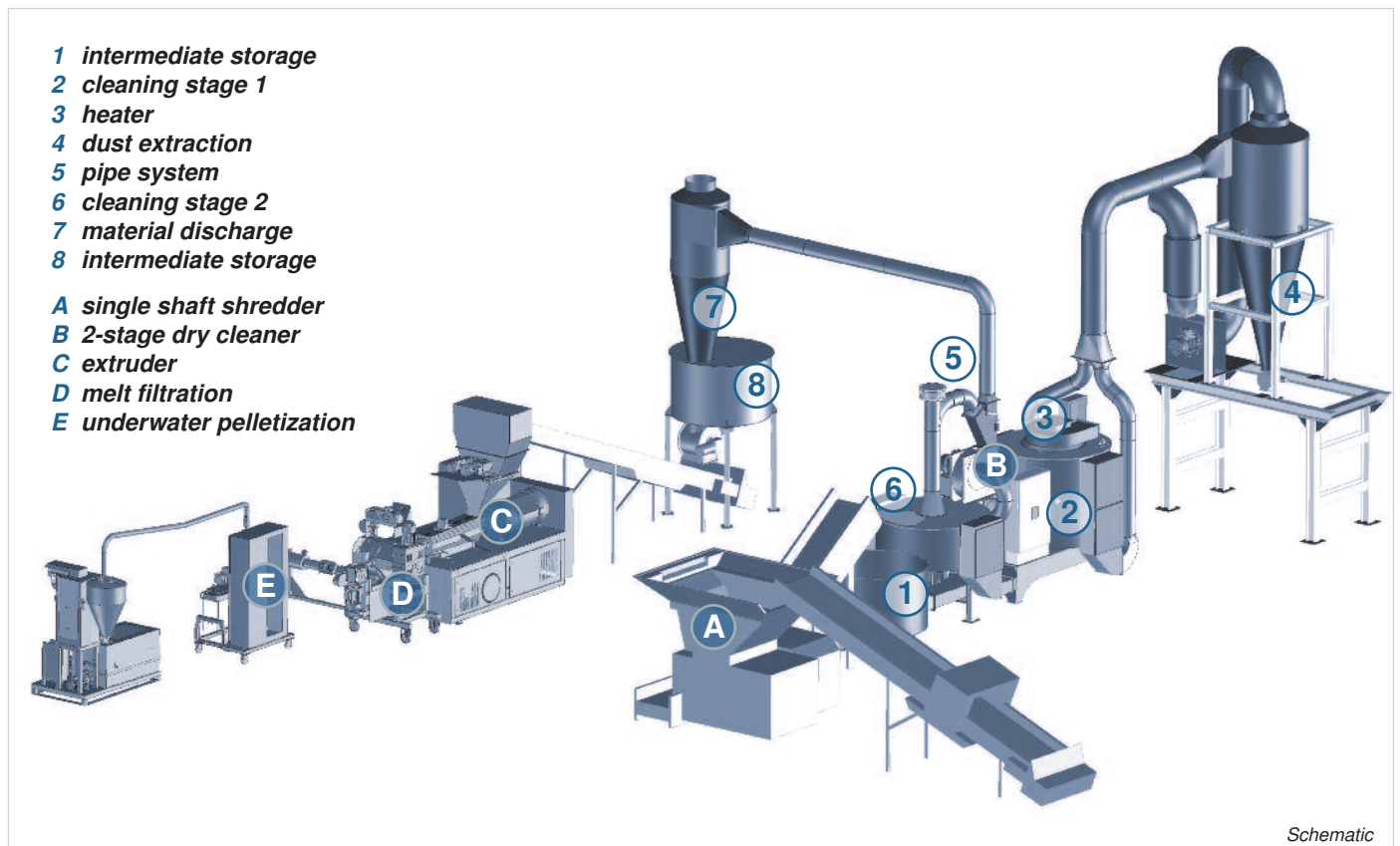
The highly efficient patented extruder featuring the NCT (New Conical Technology) principle, compounds and processes different plastics in a perfect manner - the NCT is based on a conical, co-rotating twin screw extruder. The MAS patented CDF filter technology provides reliable and continuous melt filtration to separate paper, aluminium and wood.

Complete : Systems

MAS drying and cleaning systems consist of a single-shaft shredder, material storage facility, dry cleaning unit and conveyors. The material is temporarily stored in a silo. The plastic film flakes are then metered into the extruder volumetrically by a screw feeder. Alternatively the flakes can be fed gravimetrically, with the option to compound additives, improving the quality of the plastic. Downstream melt filtration removes the remaining impurities from the melt prior to entering the die head of the underwater pelletiser. The plastic pellets are then dewatered and run through a centrifugal dryer. Significant energy saving is provided due to recovery of energy included in the pelletizing process water and by using a recuperator in order to re-use the warm air of the dryer exhaust stream.



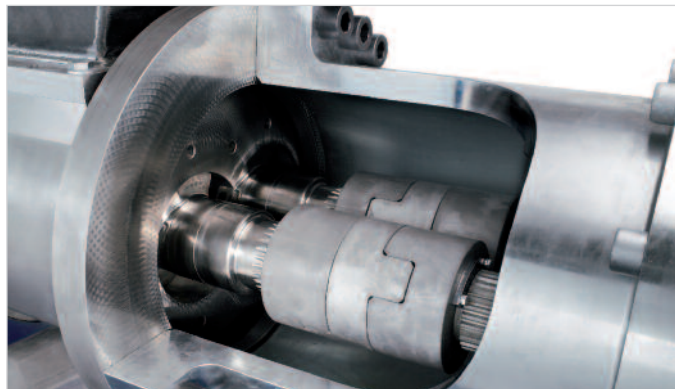
Compact System



Why MAS compact systems deliver the goods.

Practical : Maintenance

Clear design provides a unique coupling housing, which allows easy movement of the barrel for fast demounting of extruder screws. Cleaning the processing unit, if required, or re-placing the mixing parts of the screws, is possible in a very short time.



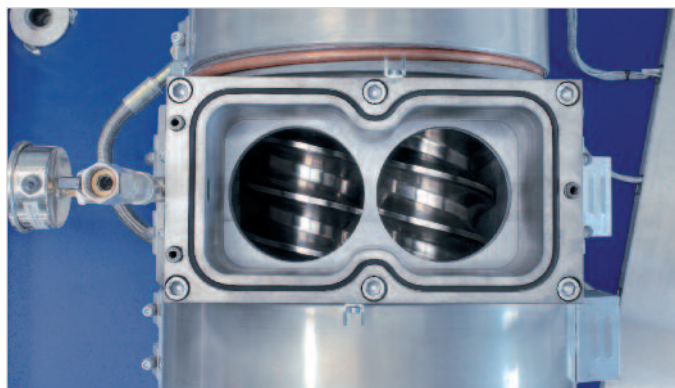
Logical : Operation

The control system, based on an industrial PC (1.1 GHz) with touch screen panel, is simple and logical to operate. The system offers a wide range of functions, such as a formula storage, production and trend analyses, recording and storing of production data plus remote telephone / GSM / WLAN maintenance.



Effective : Degassing

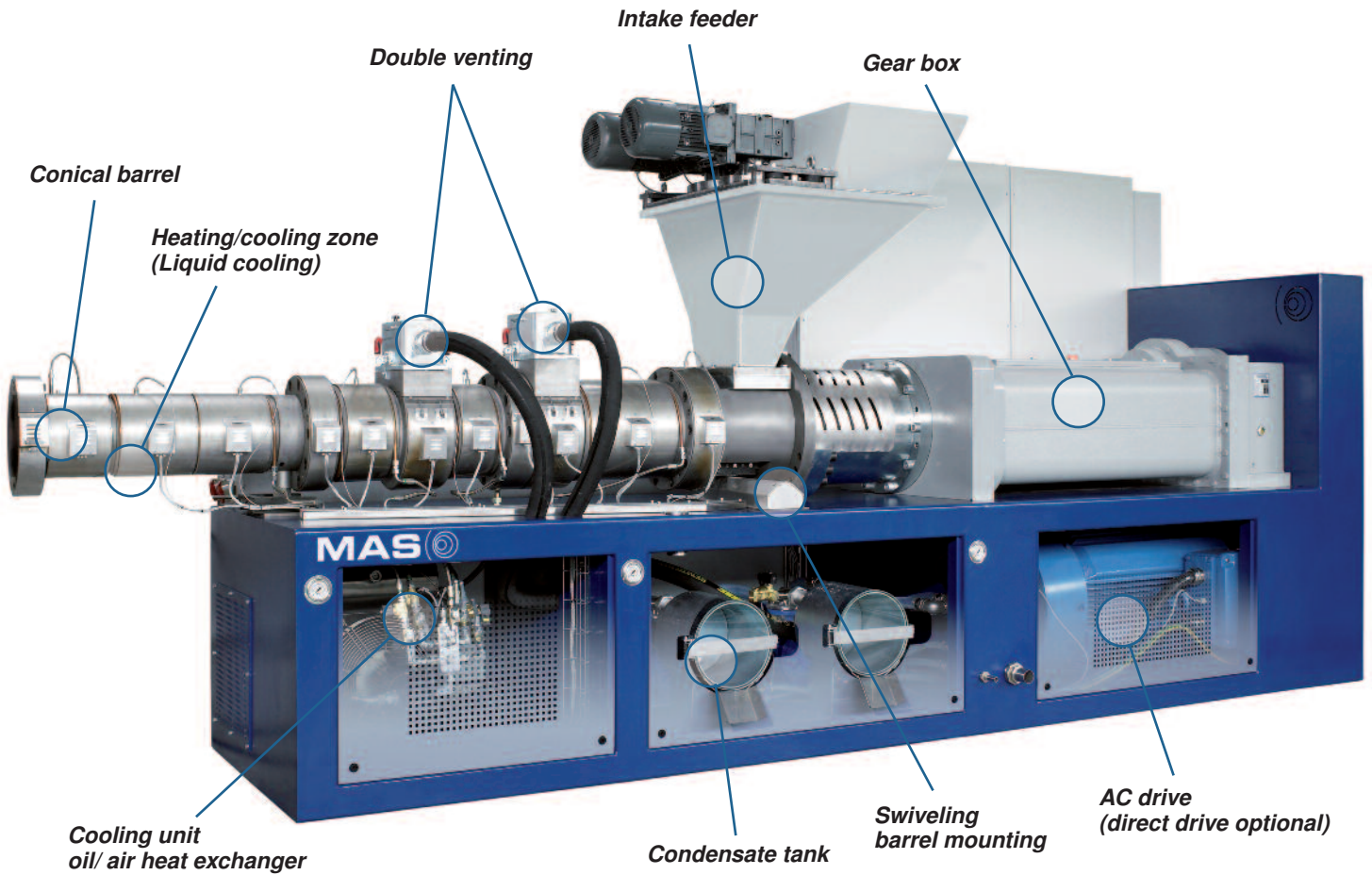
In recycling lots of materials tend to generate gases, when processed. Films in particular, but also adhesives, residual water and monomers release gases during the extrusion process. Tailor-made venting ports, exactly adjusted to each application and supported by an efficient double venting system, ensure a proper degassing of the melt. Both zones of the double venting can be operated independently with two impartial vacuum pumps, or both degassing zones are combined in order to create one big degassing area.



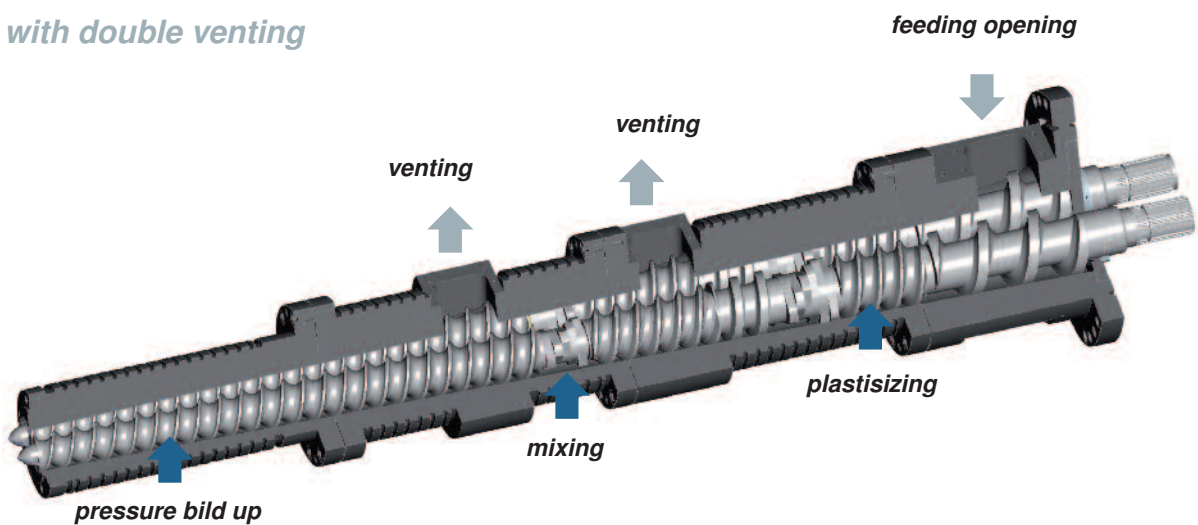
Individual : Configuration

The extruder screw consists of a rear part and a front part. Each is manufactured from one piece and is available in different pitch and flight design. Tailor made mixing and shearing elements are placed in between rear and front part. The barrel zones are equipped with heating elements and an air or liquid cooling on request.





Barrel with double venting



Schematic

MAS extruder:

Built for permanently high performance.

Perfect : Mechanics

Due to a robust mechanical engineering, MAS extruders have a particularly long service life and are easy to service. The conical design of the screw ensures minimal mechanical stress in the screw shaft, even at extremely high torques. The large intake zone centre-to-centre distances enable the use of maximum-sized drive shafts. The back-pressure bearings are also generously dimensioned. The compact design of the MAS extruder ensures a very small footprint.



Optimized : Performance

Excellent process characteristics of MAS extruders are provided by the huge material intake volume and high overlapping of the screw flights. Due to the conical design of the processing unit, the intake volume is significantly bigger than the discharge volume, resulting in a very high screw filling level. The melting zone is specified by an exceptionally large inner/outer diameter ratio. Consequently, MAS extruders offer an outstanding homogenization and mixing performance. High discharge rates can therefore be achieved even at low screw speed, providing high melt pressures at low melt temperatures. In most cases, melt pumps are not required.

Robust : Material and design

Premium quality steel, robust design and quality workmanship guarantee high availability and a long life time. Barrels and screws are designed for maximum wear-resistant: The barrels are

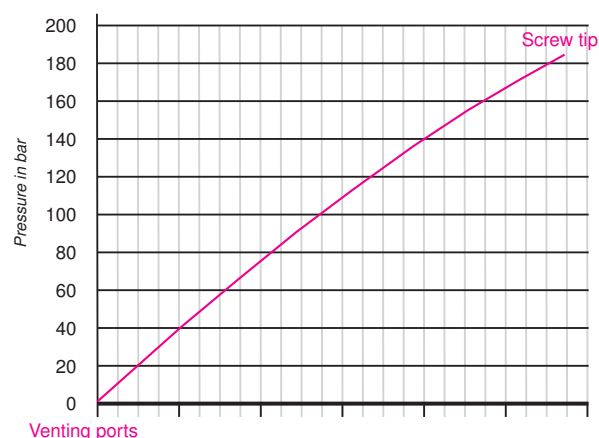
made of tool steel, case hardened or nitrited, with the screws being hardened, tempered and nitrited.

Impressive : melt pressure built up

The conical screw design allows high and stable melt pressure built up, supported by the well designed geometry of the discharge section and robust, large back pressure bearings with a minimum service life of 40,000 hours, calculated at a pressure of 250 bar.



Melt pressure in barrel

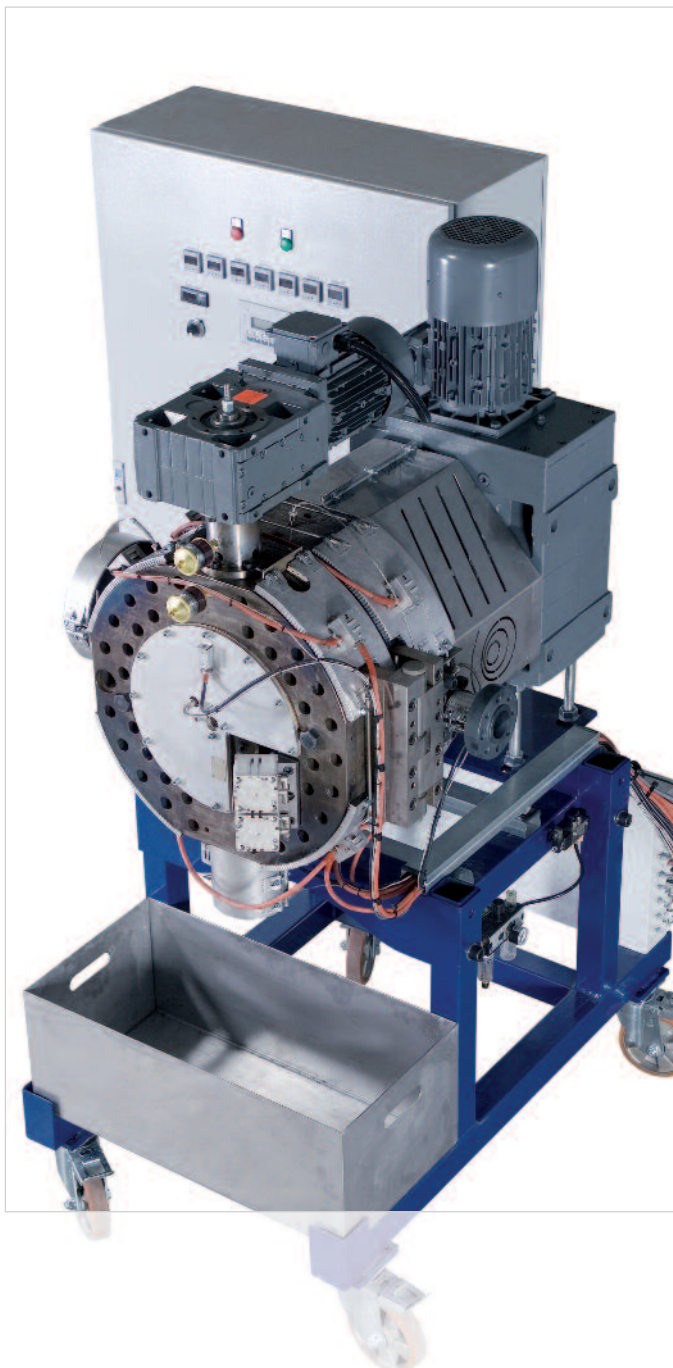


Pressure profile MAS 55 for a mass throughput of 500 kg/h, 270 rpm

The MAS melt filter ensures constant filtration quality.

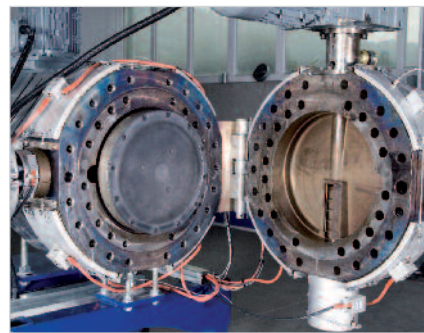
Continuous : Melt filtration

Wood and paper are very common impurities in plastic recycling. Conventional filter systems using mesh screens are usually unable to cope with even small amounts of such impurities. The continuous CDF-type melt filter separates contamination such as paper, wood, aluminum or rubber efficiently. A scraper removes the contamination from the surface of a rotating screen disc. The impurities are discharged continuously from the CDF, while the filtrated melt is forwarded to the pelletizing system. The melt pressure in front of the filtration disc controls automatically the function of the Scraper.

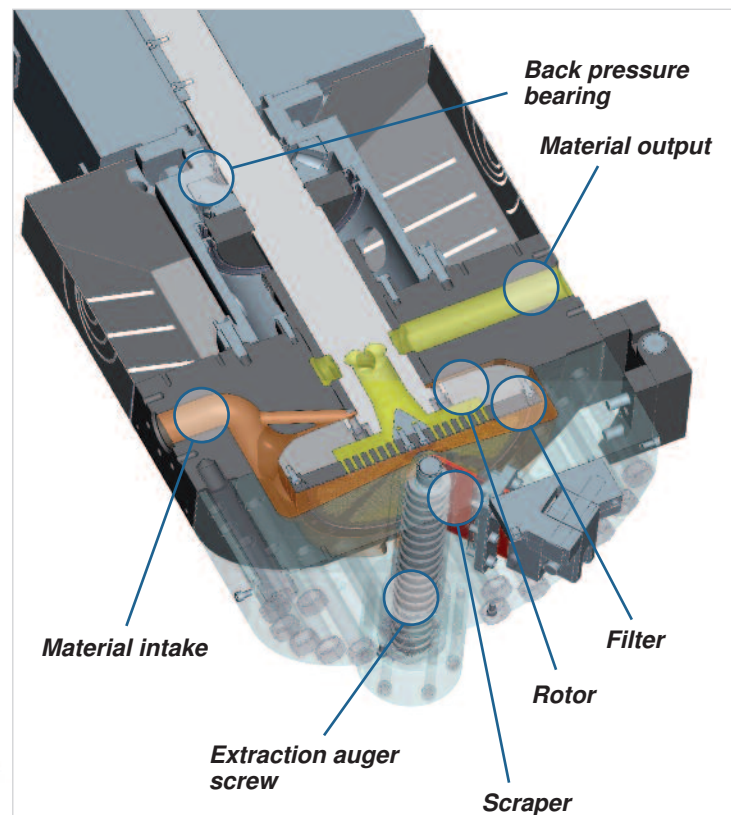


Easy maintenance : Filter disc replacement

The filter discs are manufactured from hardened steel with hole sizes from 180 µm up to 800 µm. Replacement is very simple as the filter screen is freely accessible once the split housing has been opened. Consequently, the filter screen can be replaced within approximately 40 min using conventional tools.

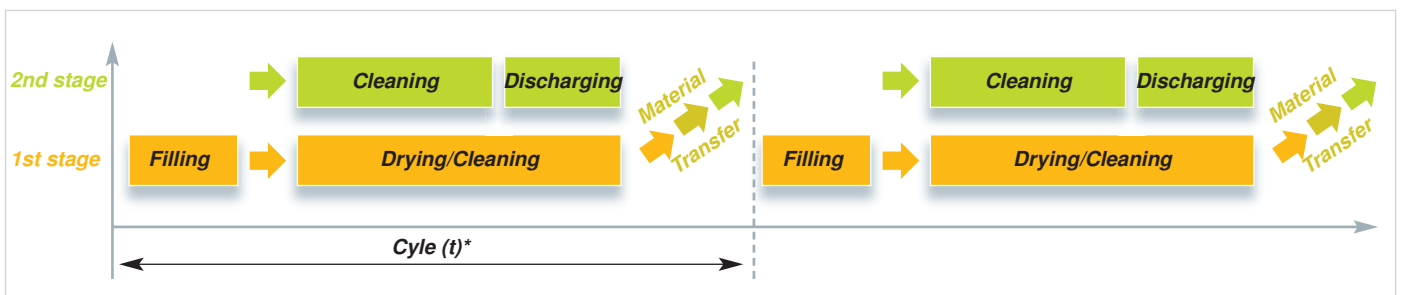


CDF Filter shown with cover opened



Schematic

How the MAS compact system cleans up in performance.



Reliable : Dry- Cleaning process

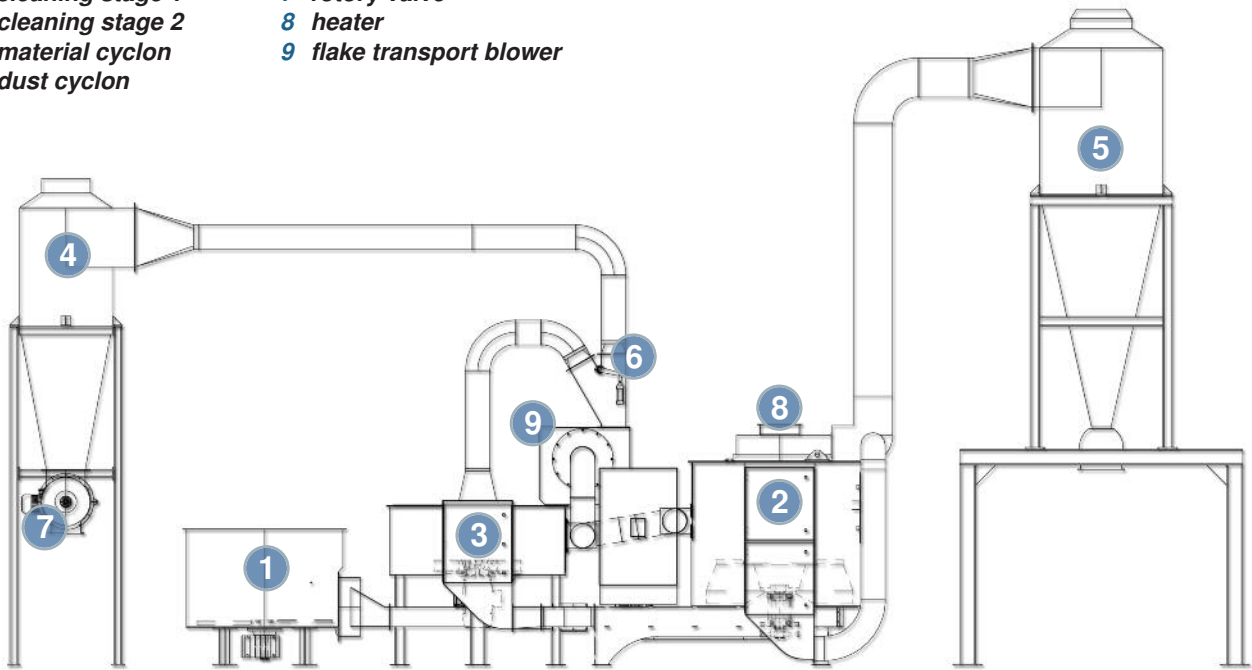
After the plastic waste is shredded, the dry cleaning unit is continually fed from the buffer silo with batches weighing up to approx. 30 kg. The cleaning process is completely dry, based on the well proven DRD system: The plastic material rotates in a cylindrical chamber, is engulfed in hot air and kept in suspension. The turbulent airflow ensures an excellent drying effect. At the same time,

impurities such as sand, soil, or fibres are separated by the screens.

The pre-cleaned flakes are then discharged and transported automatically into a second cleaning chamber to remove remaining impurities. High speeds and large air quantities ensure separation of fine dust particles. Both cleaning cycles run parallel, fully automatically controlled, substantially increasing the performance of the overall system.

Schematic

- 1 intermediate storage
- 2 cleaning stage 1
- 3 cleaning stage 2
- 4 material cyclon
- 5 dust cyclon
- 6 diverter valve
- 7 rotary valve
- 8 heater
- 9 flake transport blower



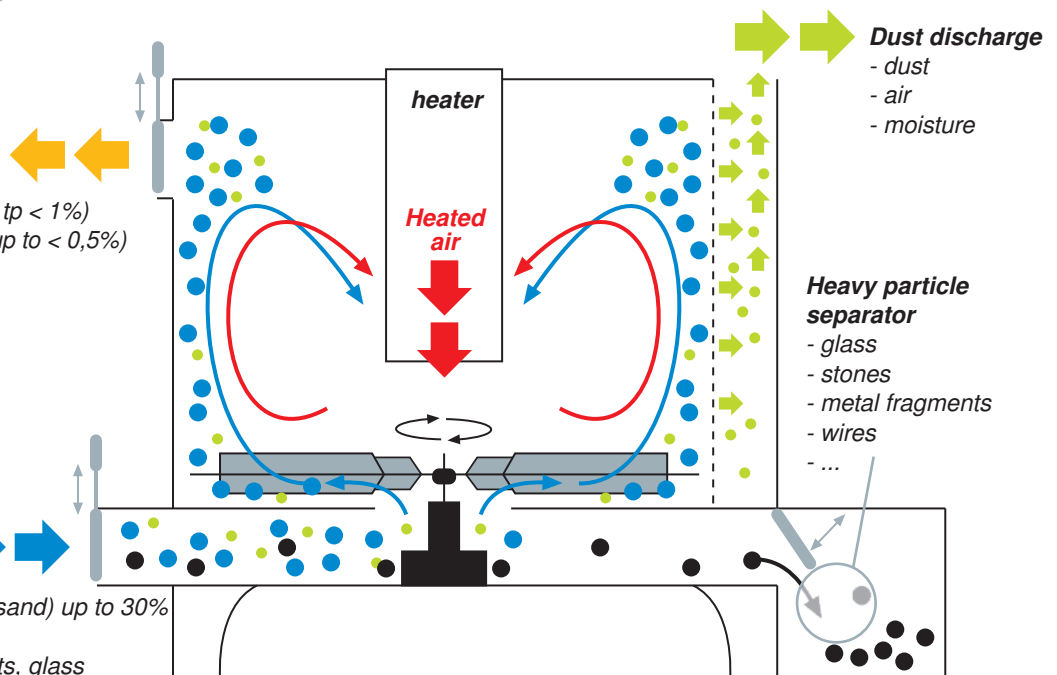
Cleaning principle

**Cleaning principle
 Material discharge**

- Material:**
- Dry* (residual moisture up to < 1%)
 - clean* (residual moisture up to < 0,5%)

- ↑↓ Scraper
- Material
- Dust
- Heavy component

- Material intake**
- Material
 - Contamination (earth, sand) up to 30%
 - Plant residuals
 - Stones, metal fragments, glass
 - Moisture up to 25%



Residual moisture and contamination depend on specification and condition of the input material

MAS compact systems

offer numerous additional benefits.

Stable : Operation

An easy-to-operate SPS controls MAS drying and cleaning systems fully automatically. Heating power and retention times can be adjusted in accordance with moisture content and the degree of contamination. The process is controlled automatically, depending on the moisture content of the input material.

A DRD-Dry-Cleaner, installed in a complete recycling process, offers major benefits:

- > higher extruder throughput due to preheated input material
- > stable extrusion process because of low residual moisture content
- > improved pellet quality due to constant flake properties
- > longer life time of melt filtration screens
- > longer extruder screw and barrel service life
- > high energy savings because of re- use of heat inside pelletizing process water and exhaust air of the DRD
- > environmental friendly process as only air is used for cleaning

smart : Energy concept

Energy consumption is kept extremely low by re-using the energy of the pelletizing process water and the heat implied in the exhaust air of the DRD.

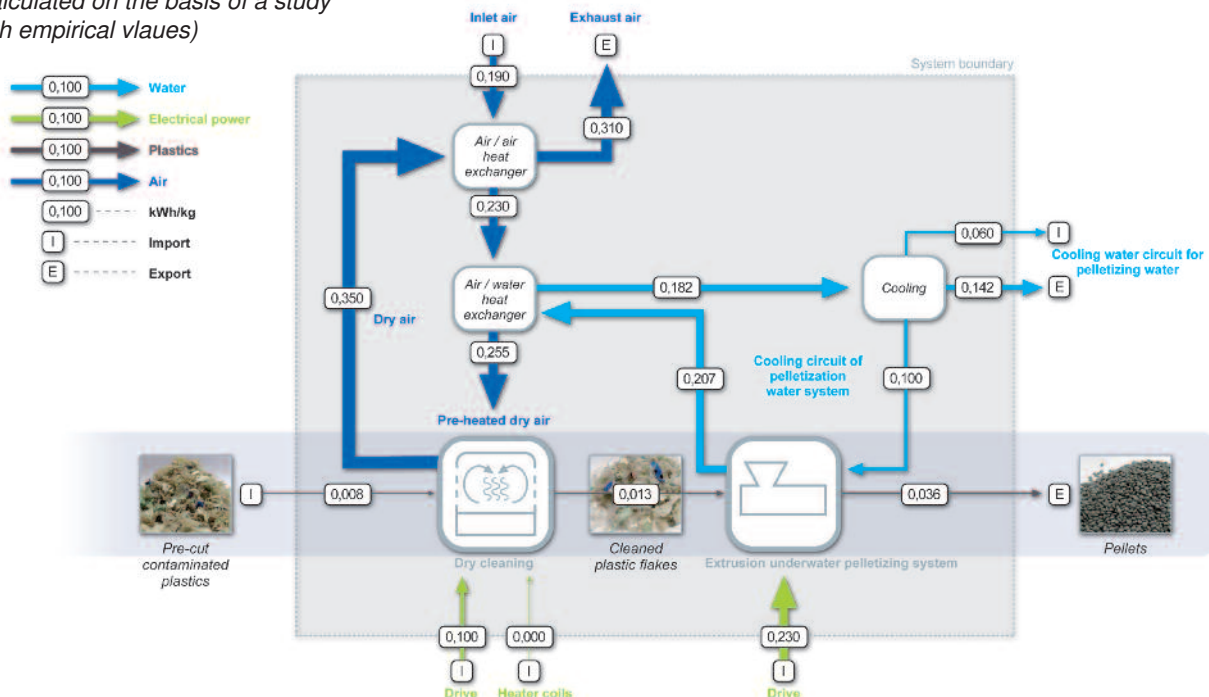


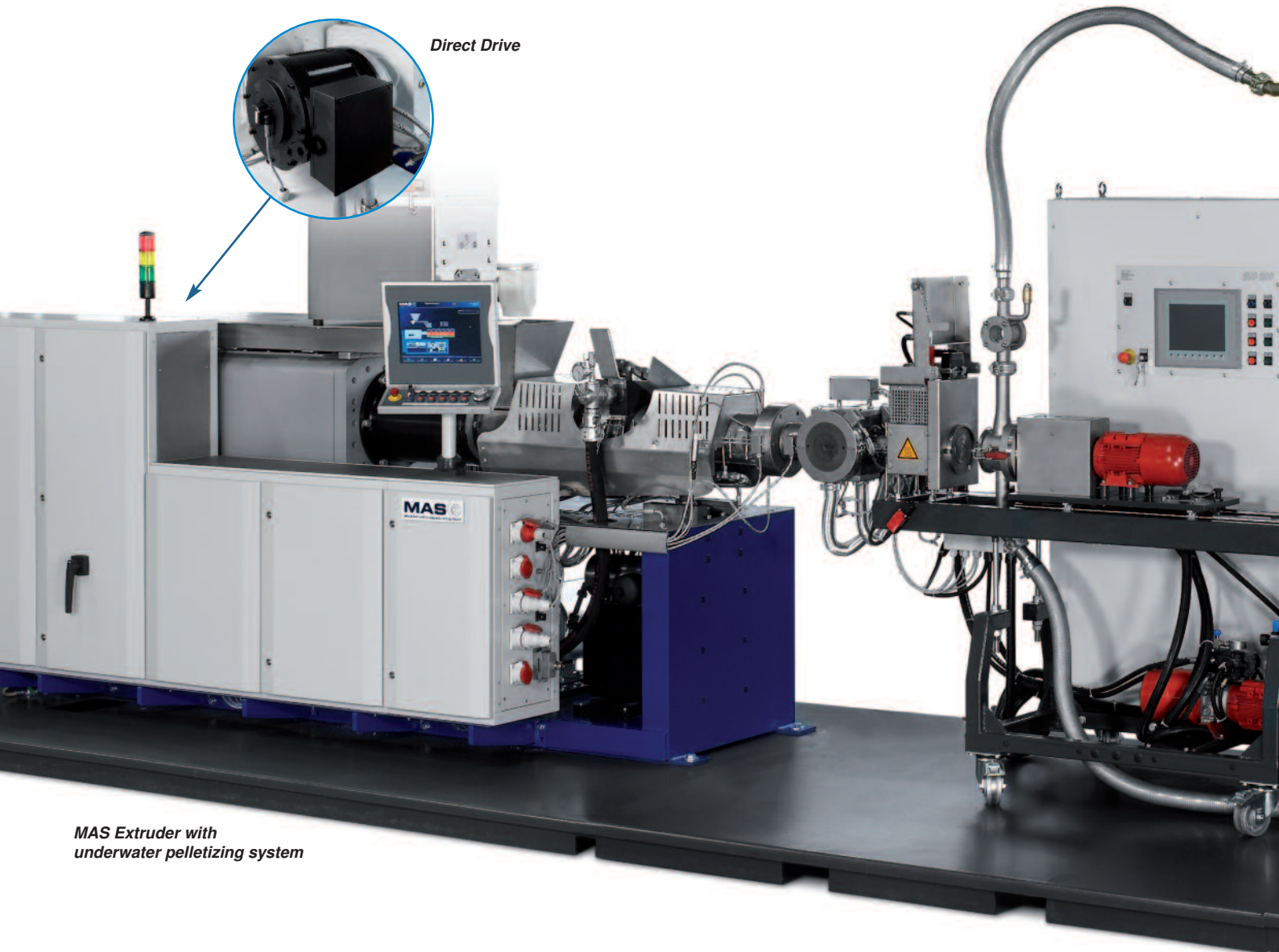
JET Filter



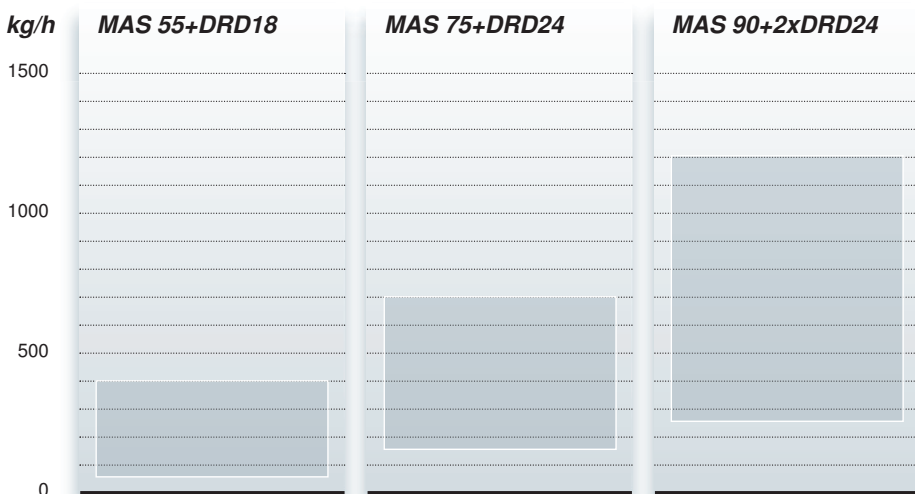
Energy balance example

(calculated on the basis of a study with empirical values)





MAS Extruder with underwater pelletizing system



Throughput data for LDPE film

Representations in

(Australia) (Europe) (Asia) (Africa) (North and South America

M-A-S Maschinen- und Anlagenbau Schulz GmbH
A-4055 Pucking, Hobelweg 1

T: +43 7229 78 999
F: +43 7229 78 999 10

info@mas-austria.com
www.mas-austria.com

MAS Austria

General Management
Günther Klammer
Tel: +43 7229 78 999 10

Sales
Stefan Lehner
Tel: +43 7229 78 999 17

MAS International

Switzerland / France
Staub Technologie GmbH
René Staub
Sonnhaldestrasse 7 A
CH-4653 Obergösgen
staub@mas-austria.com

Poland / Ukraine
MT Recycling Sp. z o.o.
Tomasz Zujkiewicz
Ul. Byslawska 82
PL-04-994 Warszawa
t.zujkiewicz@weima.pl

Spain
Elba
Ramon Xifra
Ctra. De la Bruguera, 10
ES-17150 Sant Gregori
r.xifra@cgaac.es
www.elba-spa.it

UK / Ireland

John Wood & Associates
Julian Wood
UK-14 Ladythorn Road, Bramhall
julian@johnwoodassociates.com
www.johnwoodassociates.com

Benelux

Habro Handel & Advies BV
Arjan Brouwers
Het Wolbert 19 7547
NL-RA Enschede
brouwers@winza.com
www.habrobv.nl

Sweden / Norway

Prominova AB
Erik Skoglund
S. Stationsv. 6
SE-517 33 Bollebygd
info@prominova.se

Bulgaria

Gebrüder Paschev GmbH
Daniel Paschev
Georgi Benev Str. 3
BG-4003 Plovdiv
daniel.paschev@g-paschev.com
www.g-paschev.com

Iran

Pasargad Rahpouyan Kish Co.
Kambiz Megharazi
Nr. 6 Pialeh st. Nakhjawan st.
Theran-Iran, 1975744571
pcciran@gmail.com

USA / Canada

eFACTORTHREE
Hartmut Bendfeldt
15720 John J. Delaney Drive
Charlotte, NC 28277, USA
hbendfeldt@efactor3.com
www.efactor3.com

Mexiko

Interplast, DA DE CV
Ben Propfe
José Ma. Rico No. 102 Desp. 103
Col. Del Valle
03100 México, DF
benpropfe@interplast.com.mx

Australia / New Zealand

Koga Group
Geof Pile
PO Box 6010
Victoria, Australia
geofp@koga.com.au
www.koga.com.au



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